

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014403**Date Inspected:** 18-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Yu Qi Guo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 11, Tower Shear Plate WD1-A25

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

WD1-A25B/E-2, 4, 6, 7, 10, 11, 14, 15, 18, 19, 22, 23, 26, 27, 30, 32

Bay 10, South Tower lift 3, Facade Connection Plate

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

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SSD1-FASA3-1B/E-16, 20
SSD1-FASA3-1C/E-8
SSD1-FESA3-1C/D-7, 8
SSD1-FESA3-1D/D-7, 8, 16, 17

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY11

TOWER STRUT PLATE

SMAW welding of weld joint 9A located on ED1-STSA4-6-143M-1.
Welder is identified as 044551. ZPMC QC is identified as Mr. Mao Bin Bin.
The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-U5b.

SMAW welding of weld joint 7B located on ND1-STSA4-10-119M-1.
Welder is identified as 041271. ZPMC QC is identified as Mr. Mao Bin Bin.
The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

Bearing Stiffener on Shear Plate ED1-A29

FCAW welding of weld joint 31 located on ED1-A29A/B.
Welder is identified as 040759. ZPMC QC is identified as Mr. Xu Jie.
The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

TOWER GRILLAGE PLATE

SAW welding of weld joint 3A located on GTSA5-B/G.
Welder is identified as 042195. ZPMC QC is identified as Mr. Shao Hui Long.
The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

SAW welding of weld joint 6A located on GTSA5-B/G.
Welder is identified as 044550. ZPMC QC is identified as Mr. Shao Hui Long.
The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

BAY 10

Bearing Stiffener on Shear Plate ED1-A27

FCAW welding of weld joint 24 located on ED1-A27B/E.
Welder is identified as 057258. ZPMC CWI is identified as Mr. You Qi Guo.
The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

Bearing Stiffener on Shear Plate WD1-A28

FCAW welding of weld joint 27 located on WD1-A28A/B.
Welder is identified as 053869. ZPMC QC is identified as Mr. Li Peng Fei.
The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest : 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
